

Date: Tuesday, 3/18/2008 3:55:27 PM  
User: Kim Johnston

## Process Sheet

14

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS-HANDLE
Job Number : 38090	
Estimate Number : 12989	
P.O. Number :	Part Number : D205626012
This Issue : 3/18/2008 S.O. No. :	Drawing Number : IIN D205-626 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 37493	Material :
Written By :	Due Date : 4/4/2008 Qty: <u>4</u> Um: Each
Checked & Approved By : <u>080318</u>	
Comment : Est Rev: B Reformat 00-03-03 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP 205-626-012

CHG 002

CL 08/07/03 (2 more)08/02/04 08.03.26

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2480012	Handle, Weldment (RH)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle, Weldment (LH)

Batch:

B38222 x4New BatchAS 08/07/04 (x4)

4.0	AN526C632R7	Screw
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 42.0000 Each(s)

Screw

Batch:

M106785 19X M10715 5X

5.0	AN960JD6	Washer
-----	----------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Batch:

M6085PC 8/7/3 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:55:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS-HANDLE

Job Number: 38090

Part Number: D205626012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L06

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Batch: M107898

8/7/3



7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/07/04 (X4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-626-012

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Rev D

8/07/04



9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 (X4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D205-626	REV. B SHEET 1 OF 2
DATE 96:05:14		TITLE HELI-ACCESS-HANDLE SCALE	
B	BW	96.08.14	ADD RIGHT HAND HANDLE

Qty -011	Qty -012	Part Number	Description
X		D205-626-011	DOOR HANDLE KIT LH
	X	D205-626-012	DOOR HANDLE KIT RH
1		D2480-011	HANDLE ASSEMBLY
	1	D2480-012	HANDLE ASSEMBLY
6	6	AN526C632R7	SCREW
6	6	AN960JD6	WASHER
6	6	MS21042L06	NUT

## GENERAL NOTES:

### 1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE **RESPONSIBILITY OF THE INSTALLER**. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

### 2. DAILY INSPECTION

CHECK PHYSICAL INTEGRITY AND SECURITY OF THE HANDLE(S) AND ENSURE THAT IT IS SECURELY ATTACHED.

### 3. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

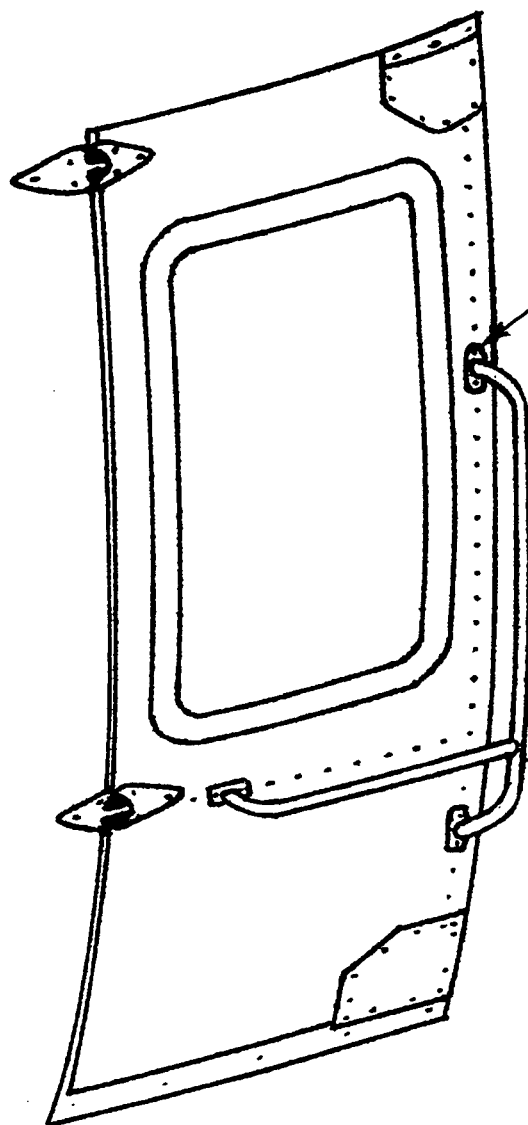
### 4. WEIGHT AND BALANCE

LATERAL				LONGITUDINAL	
Installation	weight	Arm	Moment	Arm	Moment
D205-626-011 LEFT SIDE	1.3 lb .590 Kg	-46.5 in -1.18 m	-60.45 in-lb -0.697 m-Kg	87.2 in 2.21 m	113.36 in-lb 1.31 m-Kg
D205-626-012 RIGHT SIDE	1.3 lb .590 Kg	46.5 in 1.18 m	60.45 in-lb 0.697 m-Kg	87.2 in 2.21 m	113.36 in-lb 1.31 m-Kg

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38090

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. B
CHECKED BW	APPROVED BW	D205-626	SHEET 2 OF 2
DATE 96:05:14	TITLE HELI-ACCESS-HANDLE		SCALE



TRANSFER EXISTING RIVET  
LOCATIONS TO HANDLE

AN526C632R7 SCREW (2)  
AN960JD6 WASHER (2)  
MS21042L06 NUT (2)  
(3 PLACES)

D2480 HANDLE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 38090

D205-626-011 SHOWN  
D205-626-012 OPPOSITE